

Date: Thursday, 10/18/2007 7:52:29 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	RH ACTUATOR ASSEMBLY
Job Number	35182			
Estimate Number	12770			
P.O. Number	N/A		Part Number	41232 200 001 002
This Issue	10/18/2007	S.O. No. N/A	Drawing Number	41232-200-001 REV IR
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type : SMALL /MED FAB	Drawing Revision	IR
Previous Run	31451		Material	N/A
Written By			Due Date	10/24/2007
Checked & Approved By		10/18	Qty:	1
Comment	Est Rev A	New Issue 07-02-28 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MS208224	elbow	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) elbow Batch: M104427	
2.0	AN8424D	Elbow	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Elbow Batch: M104156	
3.0	41232 200 007 001	Brass Cylinder Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Brass Cylinder Assembly Batch: B30942	
4.0	41232 200 003 001	Spring (Step Actuator)	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Spring (Step Actuator) Batch: B30941	
5.0	MS1699623	cap screw	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) cap screw Batch: M103534	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:52:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 35182

Part Number: 41232 200 001 002

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN3154R Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

M17566

W

7.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M105906

W

8.0 AN960JD10 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M105792

W

9.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

M105588

W

10.0 AN322A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

M3413

W

11.0 41232 200 005 003 Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer (Step Actuator)

31022

W

12.0 41232 200 002 005 pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pivot arm

31778

67112/04 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 35182		Part Number: 41232 200 001 002
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
13.0	41232 200 002 003 	latch 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) * latch Batch: <u>B 35203</u>		<u>Co 8/01/14</u>
14.0	41232 200 002 001 	tube 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) tube Batch: <u>B 31776</u>		<u>Co</u>
15.0	41232 200 008 001 	Decal 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Decal Batch: <u>31023</u>		<u>Co</u>
16.0	S 1455 	spring-step actuator (replaces 71459) 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) spring-step actuator (replaces 71459) BATCH: <u>M104079</u>		<u>Co 7/12/0 40</u>
17.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg 41232-200-001 2-Torque as per Dwg 41232-200-001		<u>ml 08/01/16</u> x1
18.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<u>Co 08/01/16 (70)</u>
19.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>PP 35060</u>		<u>1808/01/17 (70)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description:

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/07/17

Job Completion



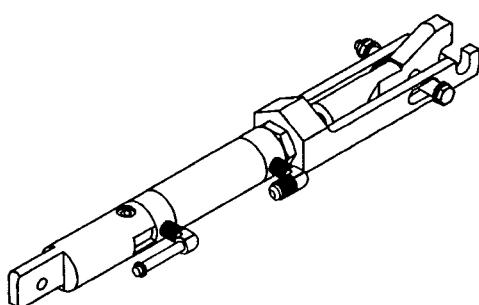
W 08.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

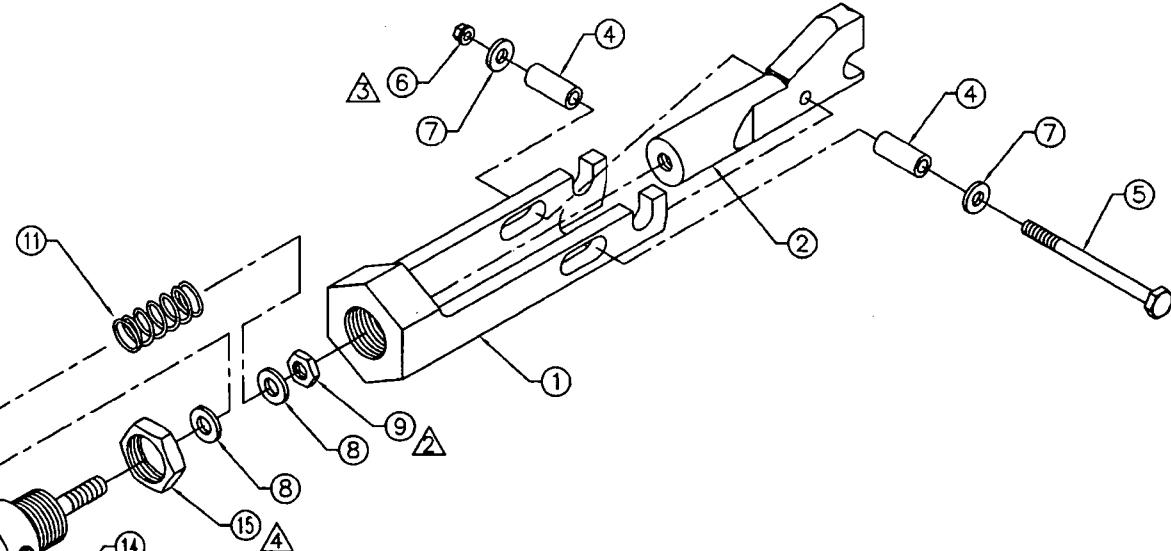
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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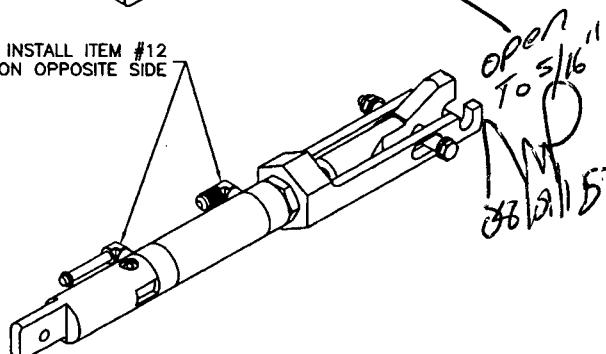
NOTE: Date & initial all entries



-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

NO.	REQ'D PER ASSY	PN NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
-002	-001	1	41232-000-001	-002 R/H ACTUATOR ASSY				
				-001 L/H ACTUATOR ASSY				

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		STRESS		PROL. ENGR.			DWG. SIZE	C
		HEAT TREAT		SCALE	NONE		REV.	
		FINISH			Era Aviation, Inc.		DWG. NO.	41232-200-001
DRAFT NO.		NEXT ASSEMBLY		REV.	IR			

- ⚠ TORQUE 80-100 IN.-LB.
- ⚠ TORQUE 20-25 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.

NOTES:

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SUBJECT TO AMENDMENT
NO. 35782
WORK ORDER
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ENGINEERING
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